

Work Order ID 69855

Friday, May 20, 2011 10:40:20 AM



Page 1

Item ID: D4038-043
 Revision ID:
 Item Name: Angle Assembly, Aft, LH
 Start Date: 5/20/2011 Start Qty: 2.00
 Required Date: 6/10/2011 Req'd Qty: 2.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: CY Date: 11/05/20 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4038	D4038 E 11.06.13

100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

110		0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg								

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

Suloc 09

EP 11/06/09 (2)

EP 11/06/09 (2)

(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69855

Friday, May 20, 2011 10:40:20 AM



Page 2

Item ID: D4038-043

Revision ID:

Item Name: Angle Assembly, Aft, LH

Start Date: 5/20/2011 Start Qty: 2.00

Required Date: 6/10/2011 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 130

0.00



Packaging

Memo

0.00

Packaging

11/6/10 (2)

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/10
MF
11-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, May 20, 2011 10:40:18 AM

Parent Item Name: Angle Assembly, Aft, LH

Required Date: 6/10/2011



Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:EC IPP
Rev:B 11.01.31 as per dwg rev.c DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

Part Number	Description	Quantity	Unit	Price	Total	Notes
D4038-3	Angle, Aft, LH	1	Each	0.0000	0.00	
D4038-7	Block	1	Each	0.0000	0.00	
D4038-11	Block	1	Each	0.0000	0.00	
AN3-14A	Bolt	2	Each	71.0000	142.00	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	21	
117513	21	
ST352	50	
117688	50	

MS21042L3	Purchased	No	100	Each	2,180.000	2	4	<i>EB 11/06/09</i>
								
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	2180	
116391	11	
116540	203	
116549	766	
117441	800	
117601	400	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 20, 2011 10:40:18 AM

Page 2

Work Order ID: 69855

Parent Item: D4038-043

Parent Item Name: Angle Assembly, Aft, LH

NAS1149D0363J

Purchased



Washer



No

100

Each

2,599.000

4

8

Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 2.00

Required Qty: 2.00



EB 5/26/09

8

Location

Loc Qty

Loc Code

ST298

2599

116583

599

117291

1000

117505

500

117601

500

Friday, May 20, 2011 10:40:18 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

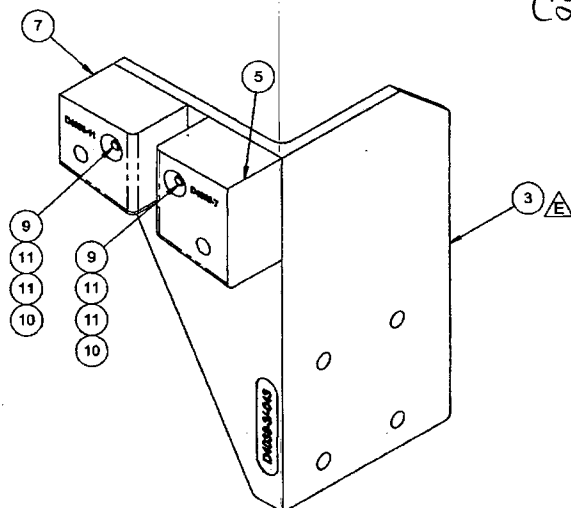
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

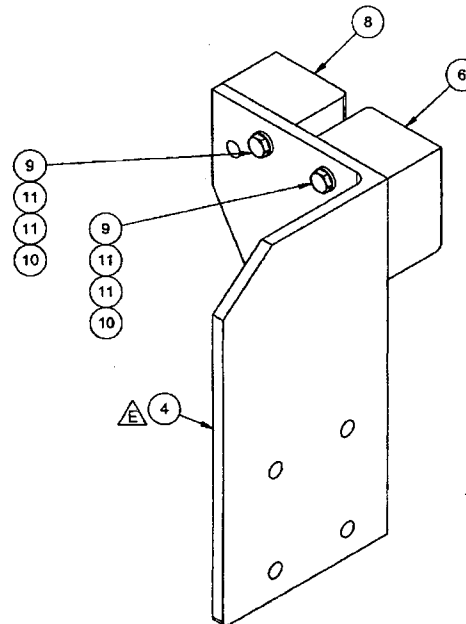
NOTE: Date & initial all entries

ITEM NO.	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X		D4038-043	ANGLE ASSEMBLY, AFT, LH
2		X	D4038-044	ANGLE ASSEMBLY, AFT, RH
3	1		D4038-3	ANGLE, AFT, LH
4		1	D4038-4	ANGLE, AFT, RH
5	1		D4038-7	BLOCK
6		1	D4038-8	BLOCK
7	1		D4038-11	BLOCK
8		1	D4038-12	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER (AN960JD10)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69855
CL 11/05/20



D4038-043 ANGLE ASSEMBLY, AFT, LH



D4038-044 ANGLE ASSEMBLY, AFT, RH

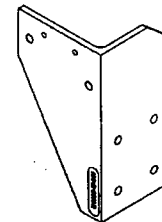
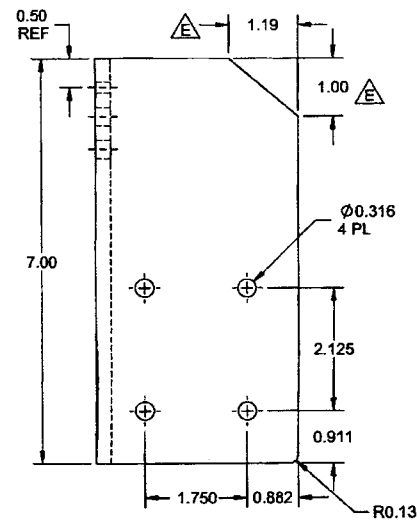
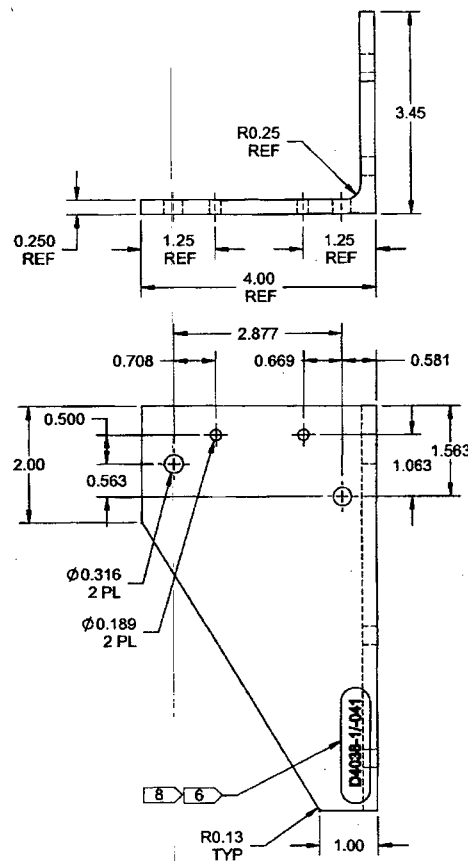
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -043 - 1.96 lbs
-044 - 1.74 lbs

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2011-04-21

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4038 REV. E
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DE APPR.		NTS
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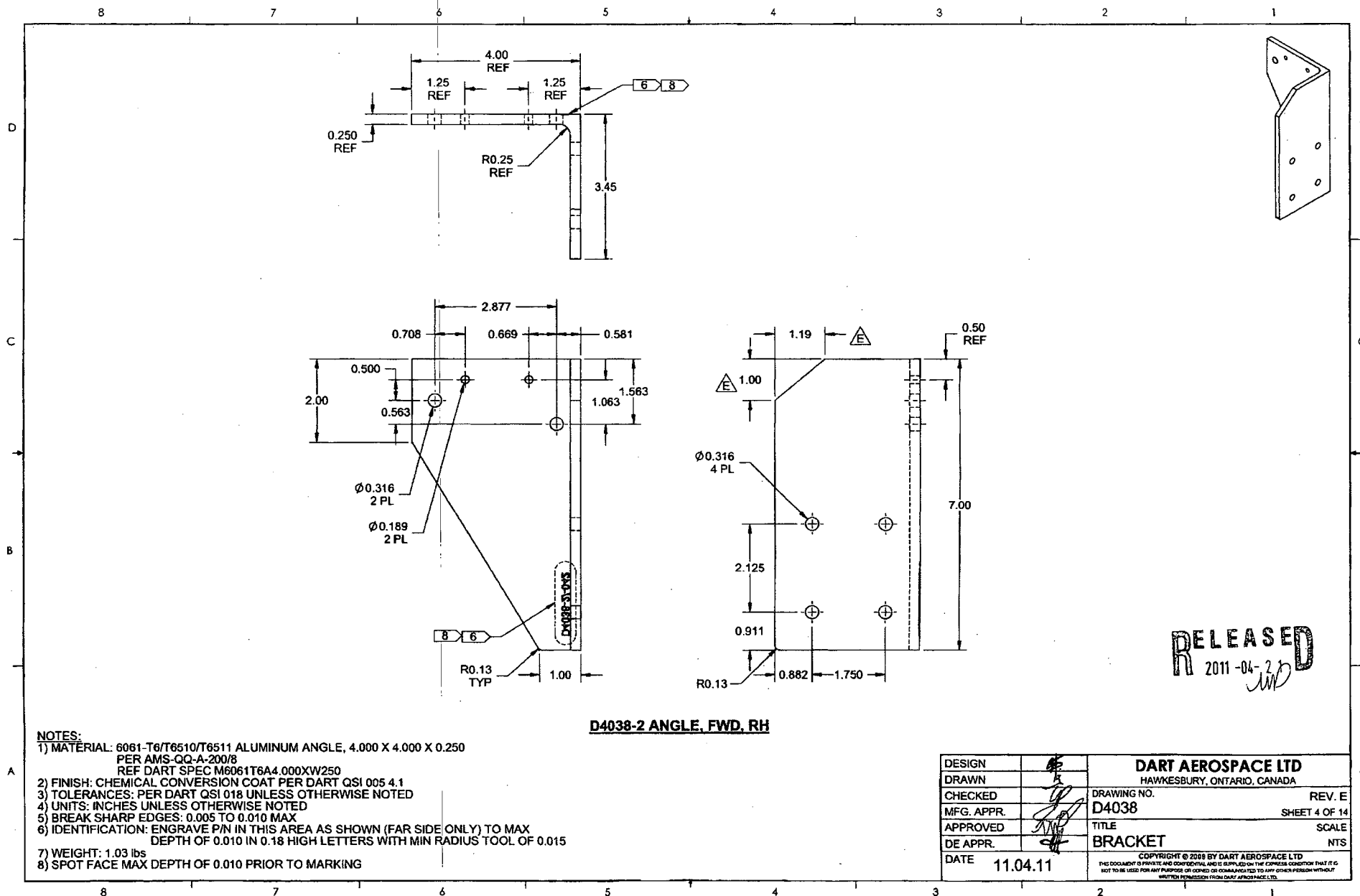
D4038-1 ANGLE, FWD, LH

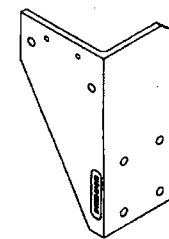
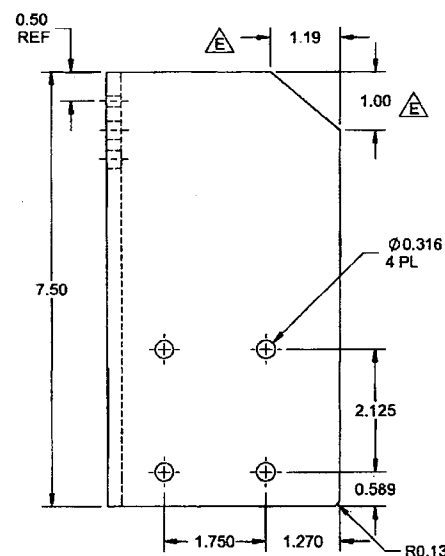
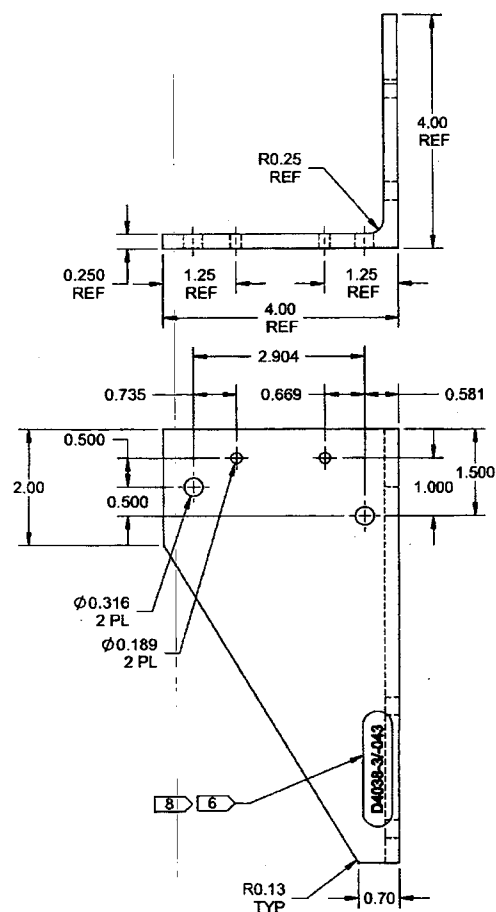
RELEASED
2011-04-21

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.03 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

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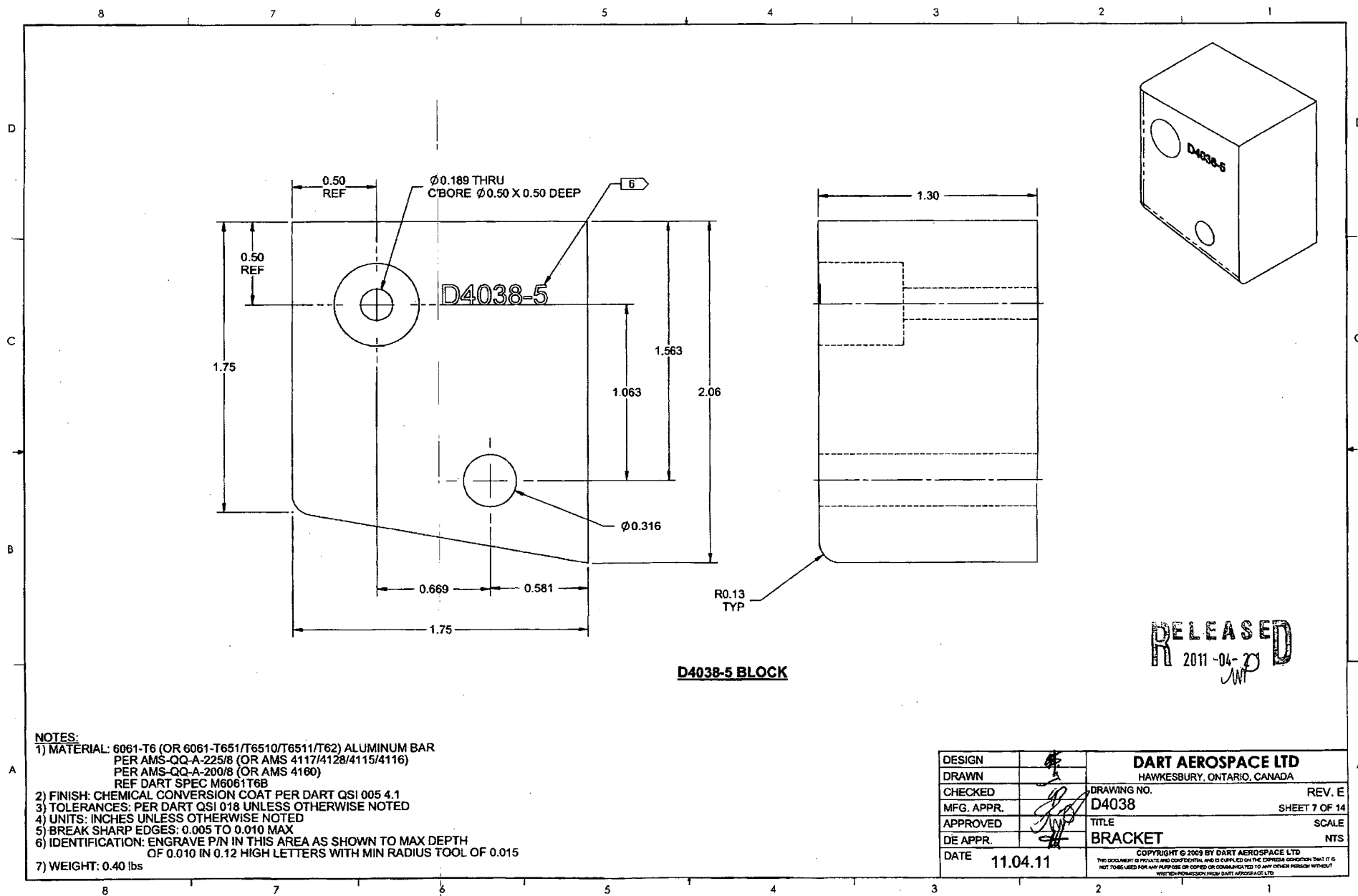
NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T8A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.18 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

D4038-3 ANGLE, AFT. LH

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2011-04-21
JMT



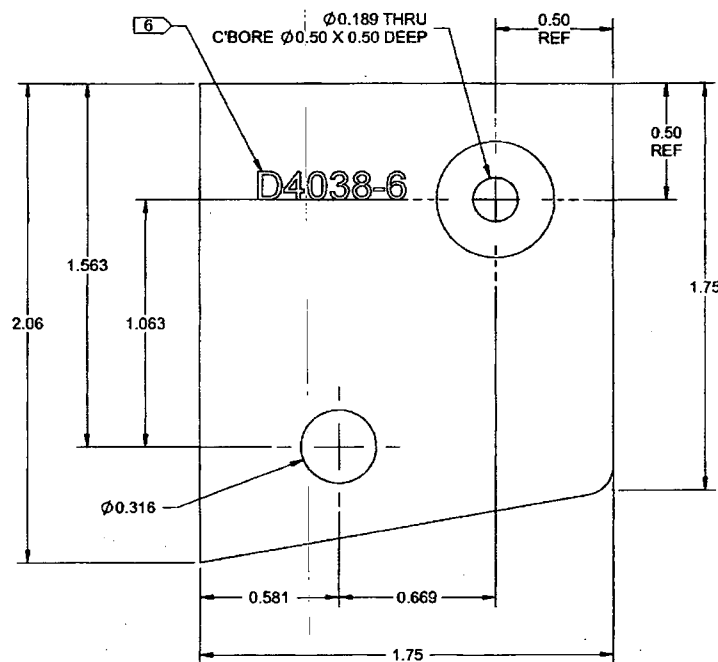
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D

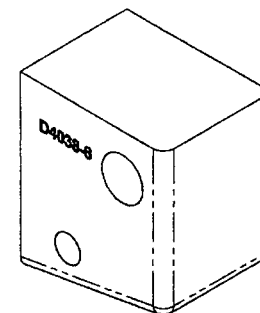
C

B

A



D4038-6 BLOCK



D

C

B

A

RELEASED
2011-04-21

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.40 lbs

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8 7 6 5 4 3 2 1

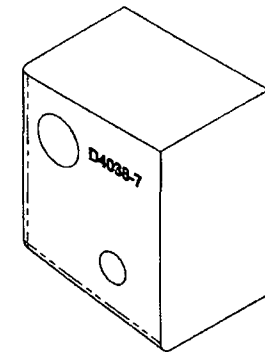
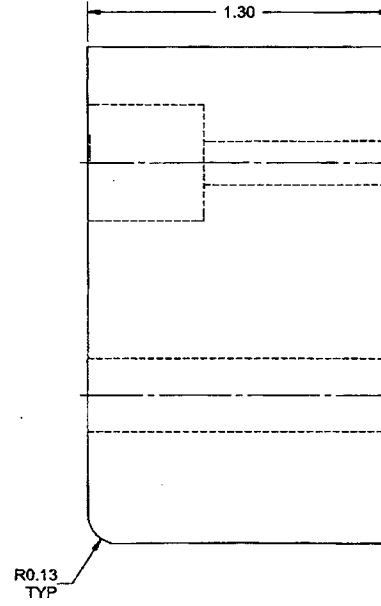
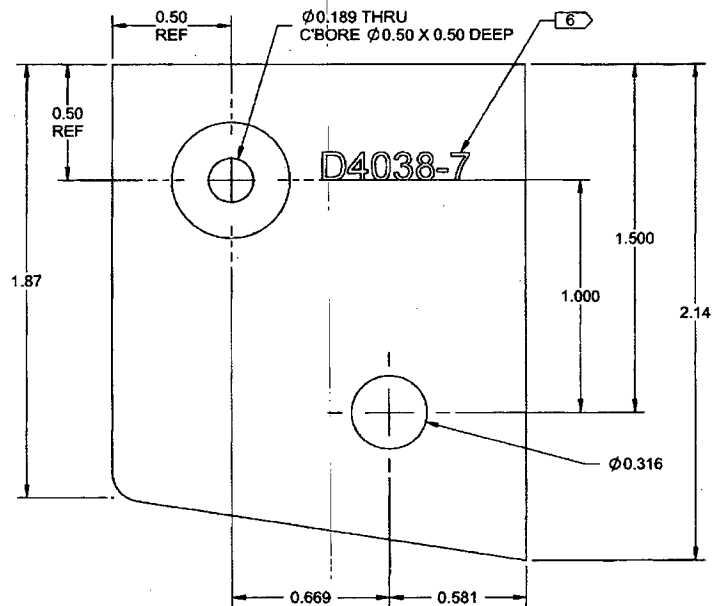
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D

C

B

A

D4038-7 BLOCK

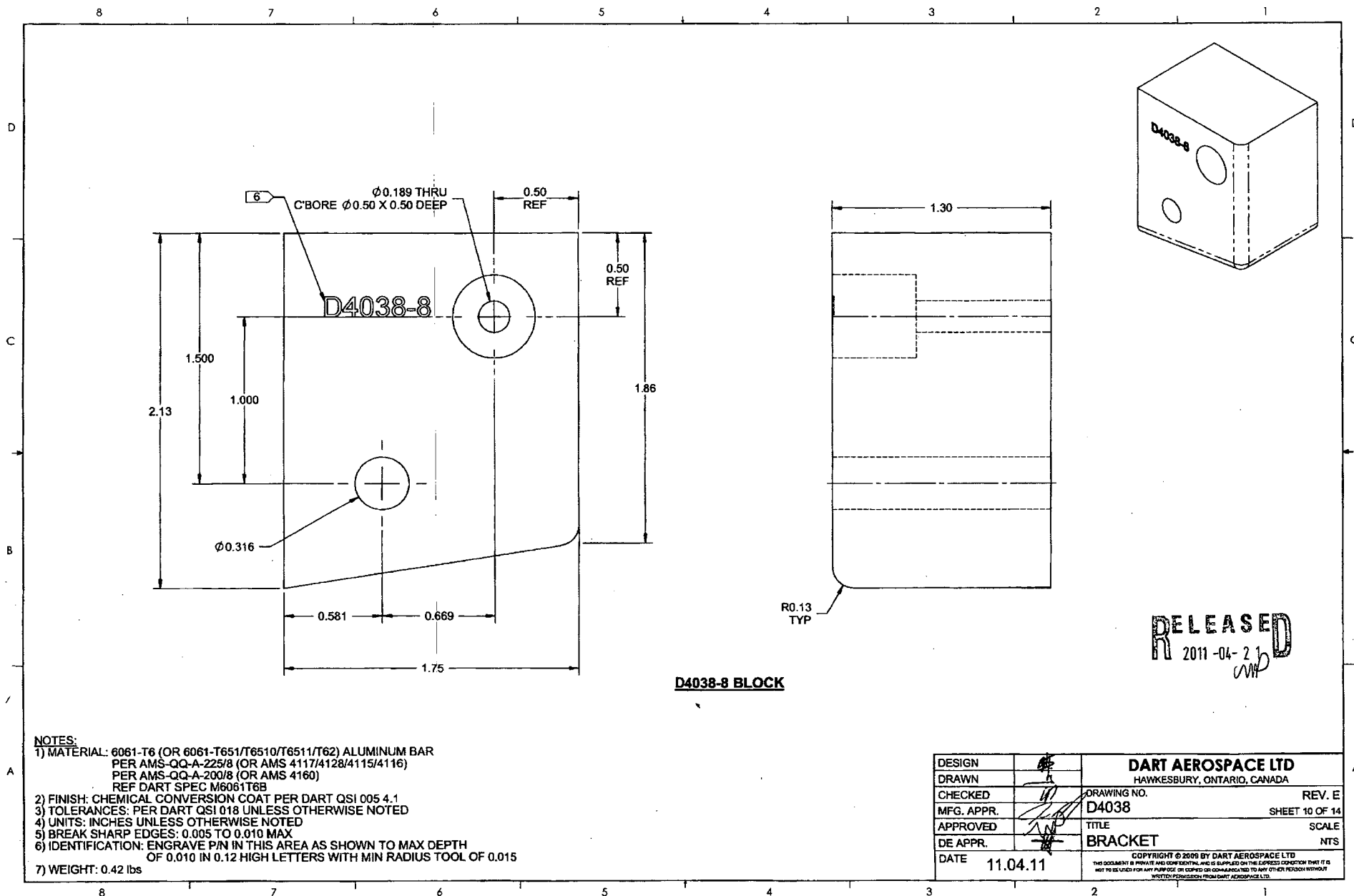
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2011-04-21
JMP

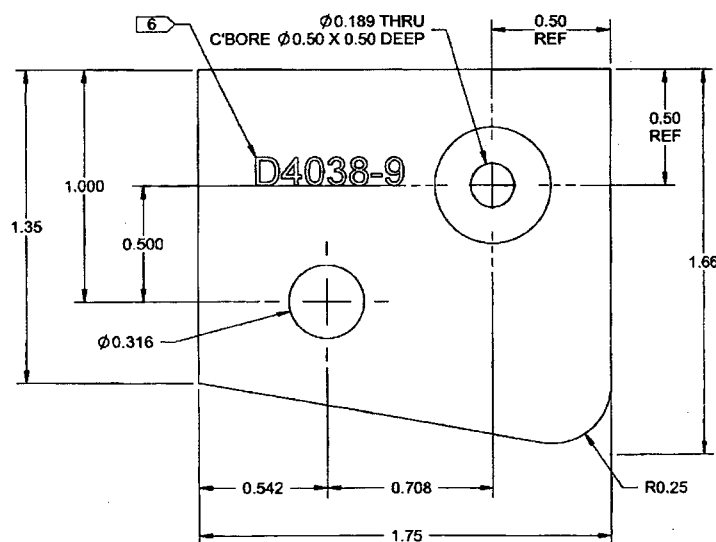
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1





NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/B (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/B (OR AMS 4160)
REF DART SPEC M6061T6B

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1


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3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED

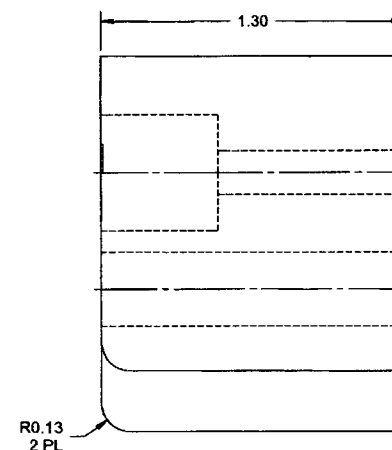
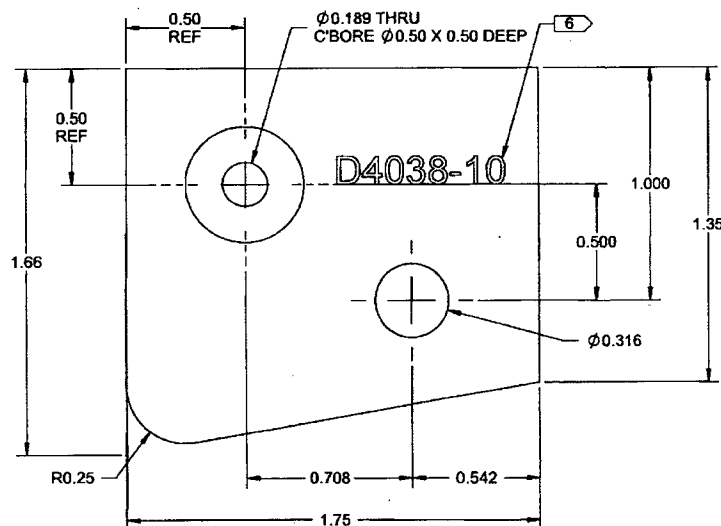
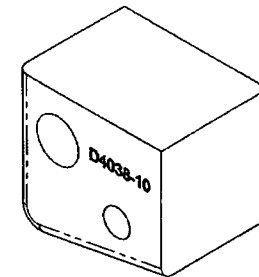
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH

6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015

7) WEIGHT: 0.31 lbs

DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			DRAWING NO.	REV. E
CHECKED			D4038	SHEET 11 OF 14
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DATE	11.04.11			



D4038-10 BLOCK

RELEASED
2011-04-23

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.31 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4038	REV. E
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DE APPR.		DATE 11.04.11	

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8 7 6 5 4 3 2 1

D

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B

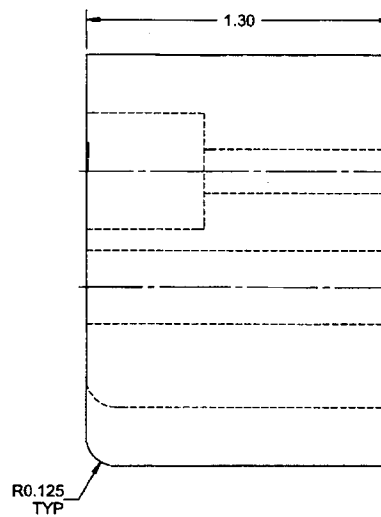
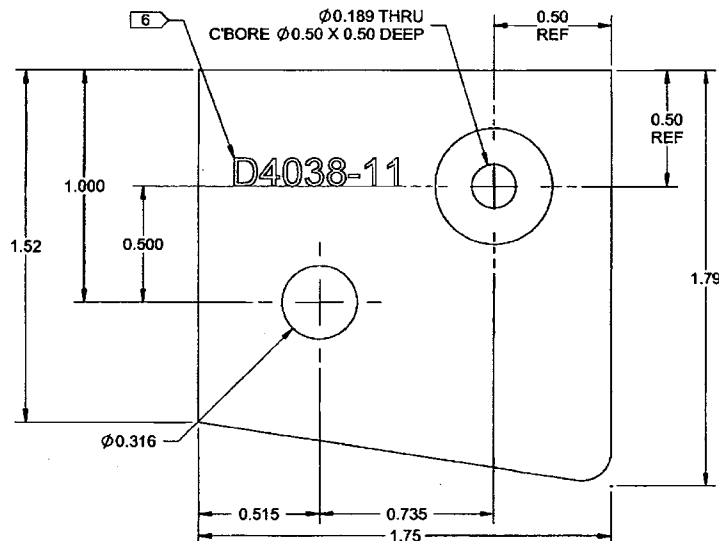
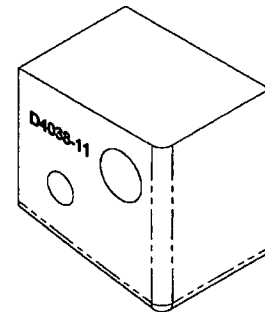
A

D

C

B

A



D4038-11 BLOCK

RELEASED
2011-04-22

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.34 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4038	SHEET 13 OF 14
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